



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246



D4842-3

Job Sheet 193033



concession required

POSITIVE RECALL

EFFECTIVE 4/27 AUTH PDRELEASED MD DATE 24 JUN 2019

DAS

Priority: Medium

55

9-89

Part No: D4842-3

Job Qty: 8 pcs

Part Name: Lower Cutter Body, LH



Part Weight: 0 lbs

Status: New

Job Created: 4/5/19

Job Tracking No:

Due Date: 5/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 16-692 DWG REV B U/R SHEET 3 IPP REV: A NEW ISSUE JFS 13/04/30 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	8 pcs	5/24/19	5/24/19	0.00	0.72	Bandsaw - 1	DIP 19-06-07 DIP 19-06-07
110	HAAS 4 Axis - B4B	8 pcs	5/24/19	5/24/19	0.00	10.00	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	8 pcs	5/24/19	5/24/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	



Container No: S188559



Part: D4842-3

Job No: 193033

Serial No/Batch: S188559

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/07/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DAS
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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
130	QC 8	8 pcs	5/24/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	Sm 19/06/18
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
140	Outsource - 4 - Anodize	8 pcs	5/24/19		ATG001-VC	8
150	Packaging 2-1 - Receive - B4B	8 pcs	5/24/19	0.00 0.00	Packaging 2 - 1 - B4B	2019-06-10
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	JUN 21 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

155	QC 5 - 6	8 pcs	5/24/19	0.00	0.00	Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
						QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
180	Packaging 3-1 - Stock - B4B	8 pcs	5/24/19	0.00	0.00	QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

POSITIVE RECALL 190 QC 21 - SA 8 pcs 5/24/19 0.00 0.00 EFFECTIVE 19.4.21 AUTH PD RELEASED 1/10 DATE 24 Jun 2019 Part Op 100 - Bandsaw - Cut Blank at 7.250"		Packaging 3 - 35 - B4B	
		Packaging 3 - 36 - B4B	
		QC 21 - SA - 21	
		QC 21 - SA - 70	
		QC 21 - SA - 53	
			DAS 55 9-89 JUN 28 2019 70 9-89
Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine per folio FB192 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG : 43081 1- Black Anodize as per Dwg D4842 150 - Receive & Inspect for Damage & Mat'l Certs 155 - QC5- Inspect part completeness to step on W/O 180 - Identify as per dwg & Stock Location: ***IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER*** 190 - QC21- Final Inspection - Work Order Release			
Job BOM			
Part / Item	Component Name	Quantity	Operation
M7075T6S1.000X5.000	7075-T6 Sheet 1" Thick Plate X 5" Wide	4.8240 ft (.603 ea)	100-Bandsaw - 1
Job Allocations			
Operation	Component Part	Required	Inventory
100-Bandsaw - 1	M7075T6S1.000X5.000	5	28
Part Specifications			
Specifications could not be found.			

MAT
used
4.866

Plex 4/5/19 1:43 PM Dart.lajeunesse.marie

$$\begin{array}{r}
 4.866' \\
 - 4.824' \\
 \hline
 \text{Scrap} \Rightarrow 0.042'
 \end{array}$$

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 197071
Description: Lower Cutter Body, LH		Part Number: D4842-3
Inspection Dwg: D4842	Rev: B	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13 x 45°	+/-0.030 x +/-0.5°	0.115 x 45°	✓		Vern.	
0.168	+0.003/-0.000	0.169	✓		D, G.	
3.68	+/-0.030	3.677	✓		Vern.	
0.43	+0.010/-0.000	0.435	✓		Vern.	
1.50	+/-0.030	1.501	✓		Vern.	
0.84	+/-0.030	0.845	✓		Vern.	
0.70	+/-0.030	0.705	✓		Vern.	
5.50	+/-0.030	5.495	✓		Vern.	
1.47	+/-0.030	1.467	✓		Vern.	
1.51	+/-0.030	1.510	✓		Vern.	
4.93	+/-0.030	4.924	✓		Vern.	
6.52	+/-0.030	6.524	✓		Vern.	
0.20	+/-0.030	0.203	✓		Vern.	
0.24	+/-0.030	0.245	✓		Vern.	
0.90	+/-0.030	0.902	✓		Vern.	
23.7°	+/-0.5°	23.7°	✓		2° Finder	
6.8°	+/-0.5°	6.8°	✓		2° Finder	
30.2°	+/-0.5°	30.2°	✓		2° Finder	
0.360	+/-0.010	0.361	✓		Vern.	
4.580	+/-0.010	4.580	✓		Vern.	
4.220	+/-0.005	4.220	✓		Vern.	
2.110	+/-0.005	2.110	✓		Vern.	
0.501	+/-0.010	0.501	✓		Vern.	
4.830	+/-0.010	4.830	✓		Vern.	
4.440	+/-0.005	4.440	✓		Vern.	
3.420	+/-0.005	3.420	✓		Vern.	
2.400	+/-0.005	2.400	✓		Vern.	
1.200	+/-0.005	1.200	✓		Vern.	
Ø0.177	+0.005/-0.001	0.177	✓		Gage Pin	
2.400	+/-0.005	2.400	✓		Vern.	
4.601	+/-0.010	4.601	✓		Vern.	
0.400	+/-0.010	0.400	✓		Vern.	

Measured by: DIP	Checked by: [Signature]	QC Inspector:
Date: 19-06-06	Date: 9/06/08	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	15.10.14	New Issue	KJ [Signature]	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043681



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043681

PO Date: 6/10/19

Due Date: 6/28/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-06-11

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193033	D4842-3	Lower Cutter Body, LH Outsource process- Anodize per QSI017 4.1.10.1 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg D4842	Firmed	-	6/28/19	8 pcs	0 pcs	8 pcs	\$18.55/pcs	\$148.40
2	193034	D4842-4	Lower Cutter Body, RH Outsource process- Anodize per QSI017 4.1.10.1 - Issue P/O to ATG : _____	Firmed	-	6/28/19	8 pcs	0 pcs	8 pcs	\$18.55/pcs	\$148.40
3	195097	RBE350A93-1280-00-03	Pin -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	6/28/19	2 pcs	0 pcs	2 pcs	\$38.30/pcs	\$76.60
Grand Total:											\$373.40

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9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043681



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to be "K. Kimberley", written over a circular stamp or seal.

Plex 6/11/19 8:11 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918028

Date: 20-Jun-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: D4842-3 Lower Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25305 PO: POHB043681	Rev: B Line: 1	DAS 40 9-89
8 ea	Part: D4842-4 Lower Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25306 PO: POHB043681	Rev: B Line: 2	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUN 20 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED

JUN 21 2019

DART AEROSPACE LTD.

